



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB6872165
Job Sheet 199588



Part No: RB6872165

Job Qty: 2 pcs

Part Name: Gauge Internal Clearance Helical Drive Gear Assembly

Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/28/19

Job Tracking No:

Due Date: 11/11/19

Created By: Chantal Lavoie

Type: SOLD

Description:

Note: DWG RB6872165 Rev 0 IPP Rev. A 19.08.27 New Issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Purchasing	DAS 2 pcs	11/11/19	0.00 0.00			Purchasing - 1	11e NOV 07 2019
	AUG 28 2019	13					Purchasing - 2	
	9-89	P04/B044334		X 2			Purchasing - 3	
110	Packaging 2-1 - Receive - B4B	2 pcs	11/11/19	0.00 0.00			Packaging 2 - 1 - B4B	11e NOV 07 2019
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	
							Packaging 2 - 4 - B4B	
							Packaging 2 - 6 - B4B	
							Packaging 2 - 7 - B4B	
							Packaging 2 - 8 - B4B	
							Packaging 2 - 9 - B4B	
							Packaging 2 - 10 - B4B	
							Packaging 2 - 11 - B4B	
							Packaging 2 - 12 - B4B	
							Packaging 2 - 13 - B4B	
							Packaging 2 - 14 - B4B	
							Packaging 2 - 15 - B4B	
							Packaging 2 - 16 - B4B	
							Packaging 2 - 17 - B4B	
							Packaging 2 - 18 - B4B	
							Packaging 2 - 19 - B4B	
							Packaging 2 - 20 - B4B	
							Packaging 2 - 21 - B4B	
							Packaging 2 - 22 - B4B	
							Packaging 2 - 23 - B4B	
							Packaging 2 - 24 - B4B	
							Packaging 2 - 25 - B4B	
							Packaging 2 - 26 - B4B	
							Packaging 2 - 27 - B4B	
							Packaging 2 - 28 - B4B	



1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S229935



Part: RB6872165

Job No: 199588

Serial No/Batch: S229935

Revision: 0

Inspector:

Exp Date:

Instructions:

Date: 11/07/19

					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
120 QC 6	2 pcs	11/11/19	0.00 0.00		QC 6 - 9	DAS
					QC 6 - 68	NOV 13 2019 68
					QC 6 - 61	9-89
					QC 6 - 40	
					QC 6 - 81	
130 Packaging 3-1 - Stock - B4B	2 pcs	11/11/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - FG	2 pcs	11/11/19	0.00 0.00		QC 21 - FG - 21	DAS
					QC 21 - FG - 70	NOV 15 2019
					QC 21 - SA - 53	

Part Op 100 - (Purchasing) Issue P/O: _____ MANUFACTURE RB6872165 AS PER DWG Supplier: ARROW TECH
 Descriptions: Certificate of conformity is required

- 110 - (Receive & Inspect for Damage & Mat'l Certs)
- 120 - (QC6- All purchased or subcontracted products)
- 130 - (Identify as per dwg & Stock Location: _____)
- 140 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
RB6872165P	HELICAL DRV GEAR ASSY INTRNL CLRNC GAGE	2 pcs (1 ea)	100-Purchasing	S2294.34
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RB6872165P	2	0	0
Part Specifications				
Specifications could not be found.				

Plex 8/28/19 10:59 AM Dart.Lavoie.Chantal



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PURCHASE ORDER

POHB044334



Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-4938
Fax: 458-215-4933

Attention: Ana
(541) 780-6938

Ship To:

PO No: POHB044334
PO Date: 8/23/19
Due Date: 11/11/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Lavoie, Chantal
Phone: 613-623-5200 Ext: 242
Fax: 613-632-1053
clavoie@dartaero.com
Pynt Terms: Net 30
Freight Terms:
Special Comments: QUOTE # 332

REVISED

Wb

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	199568	RB23003262P			LOCKNUT CRIMPER	Firmed X2		11/11/19	2 pcs	0 pcs	2 pcs	\$1,248.45/pcs	\$2,496.90
2	199569	RB23033030P			DRIFT-INSTALLATION COMPRESSOR	Firmed X2		11/11/19	2 pcs	0 pcs	2 pcs	\$293.73/pcs	\$587.46
3	199570	RB23033031P			FRONT BEARING HOUSING HOLD FIXTURE	Firmed X2		11/11/19	2 pcs	0 pcs	2 pcs	\$427.62/pcs	\$855.24
4	199571	RB23033032P			DRIFT-COMPR.FRONT BEARING OU	Firmed X2		11/11/19	2 pcs	0 pcs	2 pcs	\$376.53/pcs	\$753.06
5	199572	RB23033035P			PULLER-COMP FRONT BEARING RING	Firmed		11/11/19	2 pcs	0 pcs	2 pcs	\$3,230.00/pcs	\$6,460.00
6	199573	RB6795588P			Wrench-Holding, 32/64 Pitch 24 Tooth Spline	Firmed X2		11/11/19	2 Ea	0 Ea	2 Ea	\$918.66/Ea	\$1,837.32
7	199574	RB6795614P			Puller/Pusher Idler Gear Support Shaft	Firmed X2		11/11/19	2 Ea	0 Ea	2 Ea	\$538.00/Ea	\$1,076.00
8	199575	RB6795974P			Torquemeter Shaft Alignment Tool	Firmed		11/11/19	2 Ea	0 Ea	2 Ea	\$860.00/Ea	\$1,720.00
9	199576	RB6795984P			Power Turbine Holder Shaft	Firmed X2		11/11/19	2 Ea	0 Ea	2 Ea	\$721.00/Ea	\$1,442.00

DAS
68
9-89

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Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
10	199579	RB6796930P			Accessory Gear Box Install Plate	Firmed - X2		11/11/19	2 Ea	0 Ea	2 Ea	\$841.00/Ea	\$1,682.00
											NOV 07 2019		
11	199580	RB6796946P			Install & Removal Accessory Gear Box Bearings Drift	Firmed - X2		11/11/19	2 Ea	0 Ea	2 Ea	\$353.00/Ea	\$706.00
12	199581	RB6796948P			Drift Install/Removal Accessories Gear Box	Firmed - X2		11/11/19	2 Ea	0 Ea	2 Ea	\$310.00/Ea	\$620.00
13	199582	RB6796949P			Accessory Gear Box Bearings Installation Drift	Firmed - X2		11/11/19	2 Ea	0 Ea	2 Ea	\$292.00/Ea	\$584.00
											OCT 25 2019		
14	199583	RB6796966P			RET. RING, FUEL CTR. DR. PLIER	Firmed -		11/11/19	2 pcs	0 pcs	2 pcs	\$827.00/pcs	\$1,654.00
15	199584	RB6798047P			WRENCH OIL SUMP TURBINE	Firmed - X2		11/11/19	2 Ea	0 Ea	2 Ea	\$518.78/Ea	\$1,037.56
											OCT 25 2019		
16	199585	RB6798867P			COMP. LUBE OIL FILTER POPP VAL	Firmed - X2		11/11/19	2 pcs	0 pcs	2 pcs	\$845.25/pcs	\$1,690.50
											NOV 07 2019		
17	199586	RB6799518P			PULLER-GAS PRODUCER BALL BEARING LABYRINTH SEAL ASSEMBLY	Firmed - X2		11/11/19	2 pcs	0 pcs	2 pcs	\$792.00/pcs	\$1,584.00
											OCT 25 2019		
18	199587	RB6799973P			PULLER SEAL POWER TURBINE BELLOWS TYPE	Firmed -		11/11/19	2 Ea	0 Ea	2 Ea	\$2,291.81/Ea	\$4,583.62
19	199588	RB6872165P			HELICAL DRV GEAR ASSY INTRNL CLRNC GAGE	Firmed - X2		11/11/19	2 pcs	0 pcs	2 pcs	\$2,058.00/pcs	\$4,116.00
											NOV 07 2019		
20	199589	RB6872541P			PWR TURB SUPPORT PROTECTIVE CVR	Firmed - X2		11/11/19	2 pcs	0 pcs	2 pcs	\$380.27/pcs	\$760.54
											OCT 15 2019		
21	199590	RB6872575P			RIGGING PIN	Firmed - X2		11/11/19	2 pcs	0 pcs	2 pcs	\$319.00/pcs	\$638.00
											OCT 15 2019		

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PURCHASE ORDER

POHB044334



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Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
22	199593	RB6872746P			Puller, Power Train Drive Gear Bearing	Firmed - X2		11/11/19	2 Ea	0 Ea	2 Ea	\$1,950.00/Ea	\$3,900.00
											NOV 07 2019		
23	199594	RB6872880P			Compressor Mounting Inserts Checking Fixture	Firmed -		11/11/19	2 Ea	0 Ea	2 Ea	\$1,905.00/Ea	\$3,810.00
24	199595	RB6872927P			RED. GEAR FLANGED STUD WRENCH	Firmed - X2		11/11/19	2 pcs	0 pcs	2 pcs	\$340.64/pcs	\$681.28
											NOV 07 2019		
25	199596	RB23006778P			GUIDE SPUR ADAPTER GEAR SHAFT	Firmed - X2		11/11/19	2 pcs	0 pcs	2 pcs	\$533.00/pcs	\$1,066.00
									OCT 15 2019				
26	199597	RB23033033P			DRIFT GUIDED COMPRESSOR FRONT BEARING RING SEAL	Firmed - X2		11/11/19	2 pcs	0 pcs	2 pcs	\$858.75/pcs	\$1,717.50
											OCT 25 2019		
27	199598	RB6795969P			Holder Torquemeter Shaft Support	Firmed - X2		11/11/19	2 Ea	0 Ea	2 Ea	\$765.86/Ea	\$1,531.72
									OCT 15 2019				
28	199599	RB6796918P			Install Turbine & Exh Colct Support Oil Bellows Seal Dft	Firmed - X2		11/11/19	2 Ea	0 Ea	2 Ea	\$877.00/Ea	\$1,754.00
									OCT 15 2019				
29	199600	RB6796941P			Seals Replacement, Accessories Gear Box	Firmed - X2		11/11/19	2 Ea	0 Ea	2 Ea	\$4,053.00/Ea	\$8,106.00
									OCT 28 2019				
30	199601	RB6796950P			Accessory Gear Box Bearing Puller	Firmed - X2		11/11/19	2 Ea	0 Ea	2 Ea	\$3,698.00/Ea	\$7,396.00
									NOV 07 2019		6102 40 AON		
31	199602	RB6798292P			Wrench Ground Idle Screw Adjusting (Hinged)	Firmed - X2		11/11/19	2 pcs	0 pcs	2 pcs	\$623.21/pcs	\$1,246.42
									OCT 15 2019				
32	199603	RB6798927P			Compressor Impeller Assembly	Firmed - X2		11/11/19	2 Ea	0 Ea	2 Ea	\$1,185.00/Ea	\$2,370.00
											NOV 07 2019		
33	199604	RB6799955P			Fixture-Assembly Turbine	Firmed - X2		11/11/19	2 Ea	0 Ea	2 Ea	\$2,598.41/Ea	\$5,196.82
											NOV 07 2019		

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PURCHASE ORDER

POHB044334



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Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
34	199605	RB6872879P			SPOTFACING FIXTURE	Firmed X2	-	11/11/19	2 pcs	0 pcs NOV 07 2019	2 pcs	\$743.50/pcs	\$1,487.00
35	199606	RB6872881P			COMPR MTG INSERT WRENCH	Firmed X2	-	11/11/19	2 pcs	0 pcs NOV 07 2019	2 pcs	\$327.00/pcs	\$654.00
36	199608	RB6872882P			Turbine Front Bearing Puller	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$3,399.00/pcs	\$6,798.00
37	199610	RB6886201P			POWER TAKEOFF ROLLER BEARING GUIDE	Firmed X2	-	11/11/19	2 pcs	0 pcs	2 pcs	\$904.00/pcs	\$1,808.00
38	199611	RB6798316P			ADAPTER TURNOVER STAND	Firmed X2	-	11/11/19	2 Ea	0 Ea NOV 07 2019	2 Ea	\$807.00/Ea	\$1,614.00
Grand Total:												\$88,020.94	

Order Notes

Terms & Condition of Purchasing (Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

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PURCHASE ORDER **POHB044334**



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34		RB6872879P			SPOTFACING FIXTURE	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$743.50/pcs	\$1,487.00
35		RB6872881P			COMPR MTG INSERT WRENCH	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$327.00/pcs	\$654.00
36		RB6872882P			Turbine Front Bearing Puller	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$3,399.00/pcs	\$6,798.00
37		RB6886201P			POWER TAKEOFF ROLLER BEARING GUIDE	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$904.00/pcs	\$1,808.00
38		RB6798316P			ADAPTER TURNOVER STAND	Firmed	-	11/11/19	2 Ea	0 Ea	2 Ea	\$807.00/Ea	\$1,614.00
Grand Total:												\$88,020.94	

Order Notes

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Procurement Quality Clauses

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- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

Plex 8/23/19 1:22 PM Dart.Lavoie.Chantal



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No: HB044334

Dated: 11/04/2019

Our Order / Job No: AWT-HB044334 A19

Order Qty: 2

Part Name: HELICAL DRIVE GEAR ASSEMBLY INTRNAL CLEARANCE GAGE

Part Number RB6872165

Lot Size: N/A

Ship Date: 11/04/2019

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RB6872165

Rev: 0

Material Size and Type: -1, -2/ 4140 STEEL; -3, -4/ 1018 STEEL; -10/ O1 STEEL

Material Specifications: STEEL: ASTM A108; O1: ASTM A681

Heat Treatment: 37-38 RC

Plating/Finish: BLACK OXIDE: QMSI-6.2.2 B.O. REV-D; ZINC PLATE: ASTM B633 TYPE I SC
2

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 11/4/19

Signed: Hemant or fahd

DAS
68
9-89

PHGE Machine Works LLC dba Arrow Tech Machine Works
29751 E. Enid Rd. Unit C Eugene, Oregon 97402
Main: (541) 780-6938 | Fax: (458) 215-4938
www.atechmachineworks.com

DART SUPPLIER DEVIATION REQUEST



A. Supplier Information		B. Part Information	
Date: 10/22/19		Part Number: RB6872165-2	
Name: ArrowTech Machine Works		Description: CLAMP	
Contact: Gabriel Escobar		Revision: 0	
Phone #: 541-780-6938		PO Number: HB044334 (line 19)	
Requestor Title: Production Manager		Quantity of parts affected: 2	
C. Deviation Information			
Deviation Request is:			
Product Related ☐	1st Time ☒	Permenant ☒	Duration _____
Process Related ☒	Repeat ☐	Temporary ☒	
Current Requirement	Requested Deviation	Reason for Deviation	
1018 Material requires vapo-carbon hardening	4140 Material Heat Treated to 36-40 Rockwell.	Original material hardening process is outdated.	

DART SUPPLIER DEVIATION REQUEST



D. Corrective Action Taken		E. Preventive Action	
F. DART Approvals	Signature	Date	Approve / Disapprove
Purchasing	<i>[Signature]</i>	11/1/19	Approve
Engineering	<i>[Signature]</i>	7/9/19	Approve
Manufacturing	<i>[Signature]</i>	11-11-01	Approve
Quality	<i>[Signature]</i>	13/11/01	Approve *
Other			
G. Disposition (Completed by DART)			
Drawing Change Required?	Yes ☒ No ☐	If Yes ECN / URF Number:	
Supplier Corrective Action Request Required?	Yes ☐ No ☐	If Yes SCAR Number:	
Comments			
* For POHB044334 ONLY.			

DART SUPPLIER DEVIATION REQUEST

DART

Instructions for Completing Supplier Deviation Request Form

1. General

The Supplier Deviation Request Form is used by the Supplier to document a request for a process or product deviation. This form is to be sent to the appropriate DART Purchasing Agent for processing. No discrepant product is to be shipped until this form has been returned to the supplier with the appropriate approvals. This form is intended to be used to provide a vehicle for obtaining consent to deviate from Purchase Order Quality Clauses. This form is not to be used to notify DART of nonconforming material already shipped. The Supplier is to send the signed copy of this form with the parts.

2. Instructions

A. Supplier Information - Self Explanatory, enter all supplier information (Supplier to Complete).

B. Part Information - Enter the Part Number, Description of part, Part Revision, DART PO Number, and Quantity of product affected. NOTE: Only one SDR form per Part Number (Supplier to Complete)

C. **Deviation Information** - Identify whether the deviation request is process or product related, First Time or Repeat deviation, Permanent or Temporary and Duration if Temporary.

Current Requirement/Process - Fully describe the current requirement, specification or process.

Requested Deviation - Fully describe the requested deviation from the current requirement, specification or process.

Reason for Deviation - Fully describe the reason for the Deviation Request.

(Completed by Supplier)

D. Corrective Action Taken - Identify corrective action taken to prevent similar deviations in the future. (Completed by Supplier)

E. Preventative Action - Identify any preventative action necessary to prevent similar deviations in the future. (Completed by Supplier)

F. DART Approvals - The responsible persons from DART representing each affected department will indicate their approval or disapproval. If disapproved use Comments field to indicate why. (Completed by DART). Deviations requests may not require all signatories for approval.

G. Disposition - Identify whether the deviation request requires a permanent drawing change and the ECR / ECO number of the change.

Identify whether a Supplier Corrective Action Request is required and the CA Number. (Completed by DART)

Comments - Add any comments to the request that may provide additional information or requests within DART, e.g. Request an NC upon parts arrival for inclusion in NC metrics, reason for NA of departments, etc.

PACKING SLIP

Arrows Tech Machine Works
29751 E. Enid Road Unit C
Eugene, OR 97402
(541) 739-6938

Packing Slip Number 7109

Date: 11/4/2019

Ship Via: FED-EX

PO#: HB044334

Ship to: DART AEROSPACE
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

Bill to: DART AEROSPACE
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

Quantity

Item

Part Number

2 GAGE-INT. CLEAR. HELICAL DR. GEAR ASS.

RB6872165 REV-0

2 PULER KIT- ACCESSORY GEAR BOX

RB6796950 REV-3

RECEIVED

NOV 06 2019

DART AEROSPACE LTD.

Received by:

Checked by: *AMT*

Relabeled by: *AMT*

Page Number: